

Work Order ID 71595

Wednesday, July 06, 2011 1:27:40 PM



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Item ID:	D2053	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Bracket					
Start Date:	7/6/2011	Start Qty:	16.00		Cust Item ID:	
Required Date:	7/20/2011	Req'd Qty:	16.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/07/06</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2053	Rev C								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<u>5052</u> <u>.090</u>	1-Cut as per Dwg D2053								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	****grain direction along 1.987" ****								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B11-8-16

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B11-8-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<i>counted</i> <i>x30</i>			
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D2053 using CNC Brake	0.00 0.00				<i>30</i>			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>counted</i> <i>x30</i>			

8 wlos/16

SB, 108/30

8 wlos/30

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

30. BL 11-8-31

160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00
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Powdercoat	Memo	0.00
Powder Coating	START TIME: 9:30	
	OVEN TEMPERATURE: 3200F	
	FINISH TIME: 10:00	

M115128

170	QC3- Inspect Part Finish	0.00
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QC	Memo	0.00
Quality Control		

30X Ø M-11/01/01

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Identify as per dwg & Stock Location: <u>815</u>	0.00							
Packaging	Memo	0.00							
Packaging									
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

(30x) 8P 11-09-01

11/9/01

11-09-01

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Picklist Print

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Work Order ID: 71595



Parent Item: D2053

Parent Item Name: Mounting Bracket

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP D02.03.18 Added Rev.B NG (Issue this IPP with part number D2052)
IPP Rev:E now water jet 07-10-25 DD
IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased	No			100	sf	19.4000	0.0385	0.648421	1.5		
5052-H32 .090 Sheet													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT22	19.4						
						3019	19.4						
											3019		

B11-8-16

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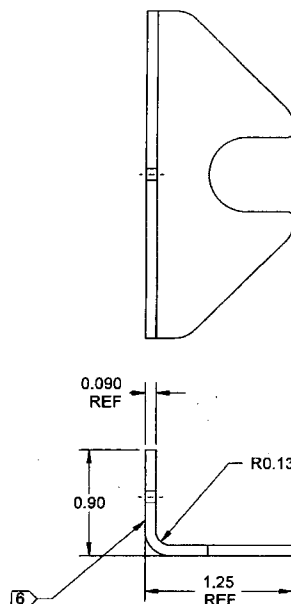
8 7 6 5 4 3 2 1

D

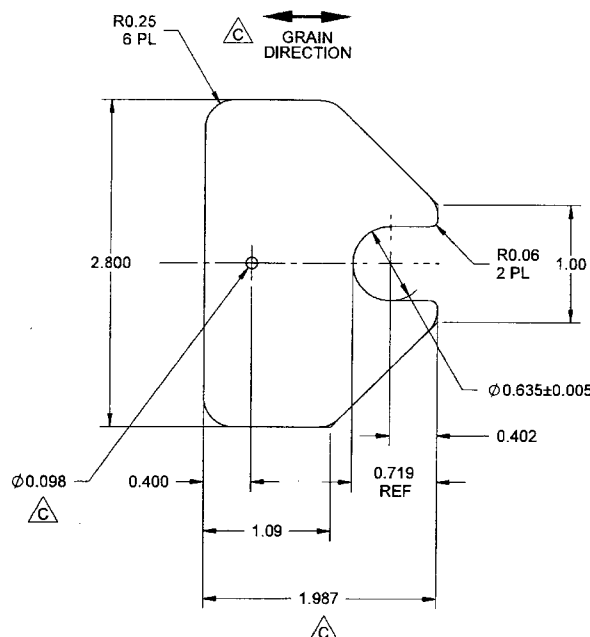
C

B

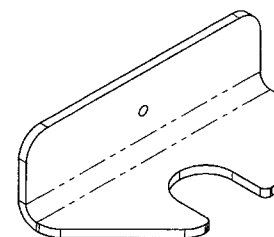
A



D2053 BRACKET



D2053F FLAT PATTERN






SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71595

CX11107106

RELEASED
08-05-13/11

- NOTES:
- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
 - 7) WEIGHT: 0.04 lbs

C	1.987 WAS 1.979 (ZN B5-1); ADD WEIGHT (ZN A8-1); ADD IDENTIFICATION (ZN A4-1); ADD 0.098 HOLE FOR POWDER COAT MOUNTING (ZN B6-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANITEX (ZN A6-1); ADD 6061-T6 MATERIAL OPTION (ZN A5-1); ADD GRAIN DIRECTION (ZN D5-1); QTY (2) 0.213 MOUNTING HOLES REMOVED; REASON: PRODUCT IMPROVEMENT		PH	08.04.25					
	B	Ø 0.635 WAS Ø 0.437; 0.635 WAS 0.325	DS	02.03.12					
A	NEW ISSUE		DS	92.01.12					
REV.		DESCRIPTION	BY	DATE					
DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
DRAWN									
CHECKED						DRAWING NO. D2053	REV. C SHEET 1 OF 1		
MFG. APPR.								TITLE BRACKET	SCALE NTS
APPROVED									
DE APPR.			COPYRIGHT © 1992 BY DART AEROSPACE LTD						
DATE			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.						
08.04.25									

8 7 6 5 4 3 2 1